

Work Order ID 85847

June-15-12 1:37:27 PM

Item ID: D3403-5

Revision ID:

Item Name: Bushing

Start Date: 15/06/2012 Start Qty: 60.00

Required Date: 29/06/2012 Req'd Qty: 60.00

Reference:

Approvals: Process Plan: MLJ

QC:

Date: 12/06/15 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

85847

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3403

D

100

Hardinge CNC LATHE SMALL

0.00

100

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1- Turn as per Folio FA925 & Dwg D3403

Folio Rev: 44

Dwg Rev: D

2-Deburr

DAS
14
9-89

12/07/30

45

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DAS
14
9-89

12/07/30

45

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

SMB
127.30

DAS
16
9-89

12/07/30

45
counts

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85847

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Item ID: D3403-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 15/06/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

130 Identify as per dwg & Stock Location: ST044

0.00

130

Packaging

Memo

0.00

Packaging

60
45 12/08/01 JB

140 QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/8/1 JB

MC512108/01

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 85847

85847

Parent Item: D3403-5

D3403-5

Parent Item Name: Bushing

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A NEW ISSUE 10-04-23 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	106.7230	0.25	15.78947			

M303R0 750

303 Round Bar 0.750

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT028	106.723	
117328	13.242	
117798	4.004	
118509	4.08	
119346	0.645	
120145	10.566	
121070	1.1	
121157	13.086	
122058	60	

M122504 X 11.8125

OK 12/07/30

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

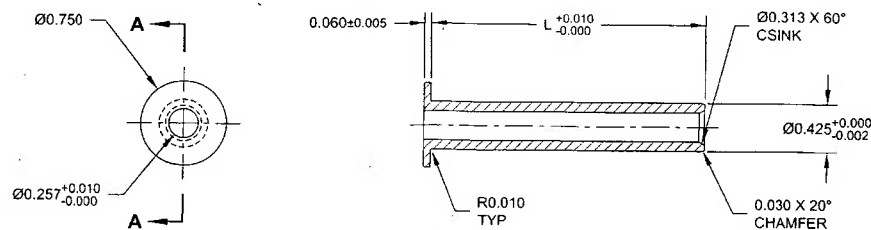
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 05847 MLJ
12/06/15



SECTION A-A

D3403-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3403-1	2.416	0.07
D3403-3	2.165	0.06
D3403-5	2.440	0.07

RELEASED
2011-10-31
WJ

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
PER ASTM A582
REF. DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

D	FOR -5, 2.440 WAS 2.500 (PER PAR 11-125)	XDF	11.10.28
C	REFORMAT TO CURRENT STD PER QSI 043; ADDED D3403-5, TOL WAS +0.005/-0.000. REASON: PAR#10-029	MB	10.04.21
B	ADD COUNTERSINK	PH	06.01.23
A	NEW ISSUE	PH	05.03.07
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	XDF		
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3403	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BUSHING	NT
DATE	11.10.28	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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